

# Work Order ID 59100

Wednesday, May 26, 2010 1:33:28 PM



Page 1

Item ID: D2512

Accept



Setup Start



Revision ID:

Item Name: Basket Lid 205/350

Stop



Start Date: 5/27/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 6/11/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

*AP*

Date:

*10-3-26*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2512

Rev E

100



Large Fab

Weld per dwg A/R S.S. rod Batch: *1005115* 0.00  
Large Fab

Memo

0.00

Large Fab

1-Cut 3/4" x 3/4" square tubing as per Dwg D2512  
2-Cut (4) D2236 From D3166-3  
3-Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305  
4-Weld as per Dwg D2512 using Welding Jig DT 9436  
Deburr as required  
\*\*\*INSTALL D2012-117 CLEVIS ONLY ON D130-701-041\*\*\*

*SAD 10-06-07*

*RD 10.06.10*

110



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds 0.00

Memo

0.00






*QC 10.06.10*



# Work Order ID 59100



Wednesday, May 26, 2010 1:33:28 PM




Page 2

Item ID: D2512 Accept  Setup Start   
Revision ID: Stop   
Item Name: Basket Lid 205/350  
Start Date: 5/27/2010 Start Qty: 1.00  Cust Item ID:  
Required Date: 6/11/2010 Req'd Qty: 1.00  Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start   
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC6- Inspect dimensions to drawing  Memo	0.00 0.00		8106609					

130  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum  Memo ① BR 10-6-9 → M 10/06/09	0.00				1			
--	---	------	--	--	--	---	--	--	--

Plug holes in D2581 and in D2327-1 bushing prior to Powdercoat

1ST COAT:  
START TIME: 12:45pm  
OVEN TEMPERATURE: 400°F  
FINISH TIME: 1:15pm

2ND COAT:  
START TIME: 1:45pm  
OVEN TEMPERATURE: 400°F  
FINISH TIME: 2:15pm

**Work Order ID 59100**

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Page 3

Item ID: D2512

Accept



Setup Start



Revision ID:

Item Name: Basket Lid 205/350

Stop



Start Date: 5/27/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 6/11/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140  HandFinish Hand Finishing	HandFinishing  Memo 112594 Wing Walk and Spray Paint black as per Dwg D2512 and QS1 005 4.4 Batch: 114432	0.00  0.00							<u>①</u> <u>10-06-10</u>
150  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00							<u>m</u> <u>10 . 06 . 10</u> <u>①</u>
160  Packaging Packaging	Identify as per dwg & Stock Location: <u>6-A</u>  Memo <u>w/o B59099</u>	0.00  0.00							<u>EB</u> <u>10/06/10</u> <u>①</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 59100**

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Page 4

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Required Date: 6/11/2010 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/10

PS 10-6-10  
①

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**NOTE:** Date & initial all entries

# Picklist Print

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Page 1

Work Order ID: 59100

Parent Item: D2512

Parent Item Name: Basket Lid 205/350

Comments: Rev IPP:M03.01.31 AddedD2012-117forD130-701-041KJ/RF  
IPP Rev:N06.04.05 Added level21  
EC IPP REV:N ADDED D3490-  
1/-3 FOR D130-701-011/-043 10-04-20 JLM VERIFIED BY:DD

Start Date: 5/27/2010

Required Date: 6/11/2010

Start Qty: 1.00

Required Qty: 1.00

D4090-1 Manufactured No

Each 5.0000



Placard



1

1

10-6-10 8/

Location

Loc Qty

Loc Code

ST112

5

57866

5

\*\*\* ONLY APPLICABLE ON D130-701-043/-011 -  
IF NOT USED, PLEASE MARK N/A \*\*\*

D4090-3 Manufactured No

Each 5.0000



Placard



1

1

10-6-10 8/

Location

Loc Qty

Loc Code

ST112

5

57865

5

\*\*\* ONLY APPLICABLE ON D130-701-043/-011 -  
IF NOT USED, PLEASE MARK N/A \*\*\*

D2012-117 Manufactured No

100 Each 39.0000



Clevis



2

2

10-06-07

Location

Loc Qty

Loc Code

WA

39

52498

9

55729

30

\*\*\* ONLY APPLICABLE ON D130-701-041 -IF  
NOT USED, PLEASE MARK N/A \*\*\*

D2232-1 Manufactured No

100 Each 36.0000



Basket Hinge



2

2

10-06-08

Location

Loc Qty

Loc Code

WA

36

55791

36

10-06-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 2

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Parent Item: D2512



Parent Item Name: Basket Lid 205/350

Start Date: 5/27/2010

Required Date: 6/11/2010

Comments: Rev IPP:M03.01.31 AddedD2012-117forD130-701-041□KJ/RF

Start Qty: 1.00

Required Qty: 1.00

IPP Rev:N□06.04.05 Added level21

EC

IPP REV:N ADDED D3490-

1/-3 FOR D130-701-011/-043 10-04-20 JLM VERIFIED BY:DD

D2327-1

Manufactured No

100 Each

25.0000

2

2



Spacer Bushing



PD 10.06.07

Location

Loc Qty

Loc Code

WA

25

52832

5

54658

20

②

D2506

Manufactured No

100 Each

7.0000

1

1



Label Plate



PD 10.06.08

Location

Loc Qty

Loc Code

WA

7

57599

2

57836

5

①

D2581

Manufactured No

100 Each

34.0000

2

2



Mounting Bracket



PD 10.06.07

Location

Loc Qty

Loc Code

WA

34

46086

2

51745

2

57185

1

58301

9

58687

20

②

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 3

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IPP Rev:N06.04.05 Added level21  
EC IPP REV:N ADDED D3490-  
1/-3 FOR D130-701-011/-043 10-04-20 JLM VERIFIED BY:DD

Start Date: 5/27/2010

Required Date: 6/11/2010

Start Qty: 1.00

Required Qty: 1.00

D3166-3 Manufactured No 100 Each 8.0003 1 1



Basket Hoop



SAO 10-06-07

Location Loc Qty Loc Code

WA 8.000321053  
55697 2.1053E-05  
56426 2.0003  
57504 6

M304EX0.75-16F Purchased No 100 sf 586.5561 18 18.94737



Expanded Metal Flat SS



SAO 10-06-07

Location Loc Qty Loc Code

MAT 586.5561368  
111956 28  
112949 12  
113497 6.34  
113555 22.2888368  
114399 108.1523  
114594 89.775  
114744 320

M304TS0.750W.065 Purchased No 100 f 1,200.557 43.5804 45.87411



304 SQ Tube .75x.75x.065W



SAO 10-06-07

Location Loc Qty Loc Code

MAT 200.5571  
112398 0  
114482 200.5571  
WA 1000  
114520 1000

45.8741

Wednesday, May 26, 2010 1:33:32 PM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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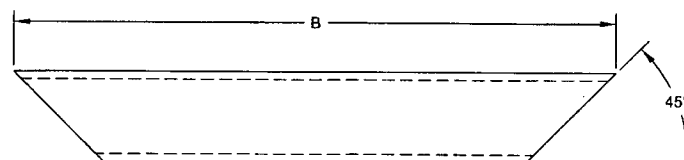
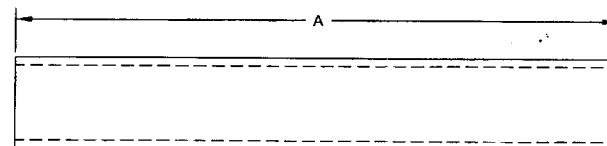
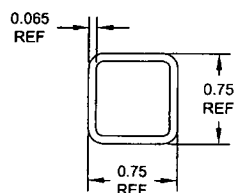
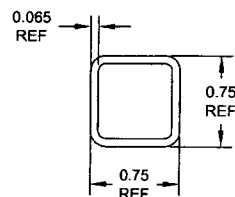
**NOTE:** Date & initial all entries

# PARTS LIST FOR D2512 BASKET LID ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2512-1	2	—	25.50	RIB
D2512-3	2	—	95.30	RIB
D2512-5	6	30.84	—	RIB
D2512-7	3	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRACKET

SHOP COPY  
RETURN TO:  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 59100  
*08-05-26*

RELEASED  
*08-08-21/11*



E

## D2512-1/-3/-5/-7 NOTES:

- 1) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING  
REF. DART SPEC M304TS0.750W.065
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST

E	INCORPORATED D1 & D2. MATERIAL FOR -1, -3, -5, & -7 WAS 0.060 WALL. SHT 3 ZN C4 TOLERANCE REMOVED FROM 95.30 DIM. DRAWING TRANSFERRED TO 'B' FORMAT AND UPADTED TO CURRENT STANDARDS. SHT 3 VIEWS INVERTED FOR CLARITY. SHT 2 MESH MATERIAL CALLOUT UPDATED.	AJS	08.06.17
D	CHANGE HINGE	CP	01.04.19
C	REMOVE DOUBLE SKIN SECTION. ADDED MEMBERS. INCORP DEO 9074	DS	99.07.06
B	ADDED LATCH CHANNEL & LABEL PLATE	BW	96.05.24
A	NEW ISSUE	BW	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
DATE	08.06.17	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

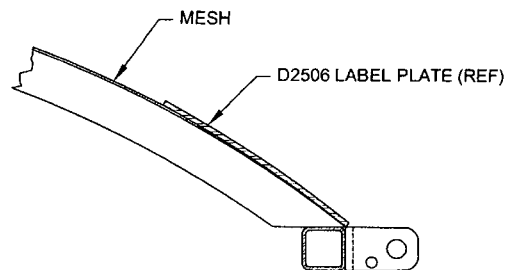
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

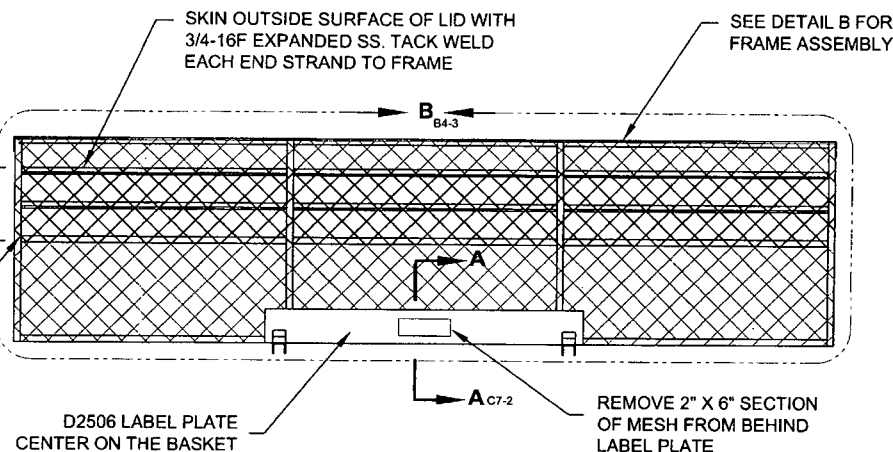
**NOTE:** Date & initial all entries



**SECTION A-A<sub>B3-2</sub>**  
(ROTATED 90° CCW)

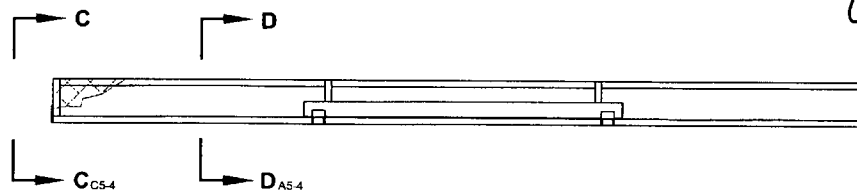
FINISH THIS SECTION ALONG  
ENTIRE LENGTH PER NOTE 3  
AFTER POWDER COAT.

TACK WELD MESH TO FRAME  
AT EVERY AVAILABLE LOCATION  
IN AREA TO BE ANTI-SKIDDED



**D2512 BASKET LID ASSEMBLY NOTES:**

- 1) MESH MATERIAL: 3/4-16F EXPANDED SS  
REF DART SPEC M304EX0.75-16F
- 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) SPRAY PAINT BLACK INSIDE SURFACE  
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: N/A
- 9) WELD PER DART QSI 004



**RELEASED**  
08.06.17

DESIGN	BW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
DATE	08.06.17	COPYRIGHT © 1993 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

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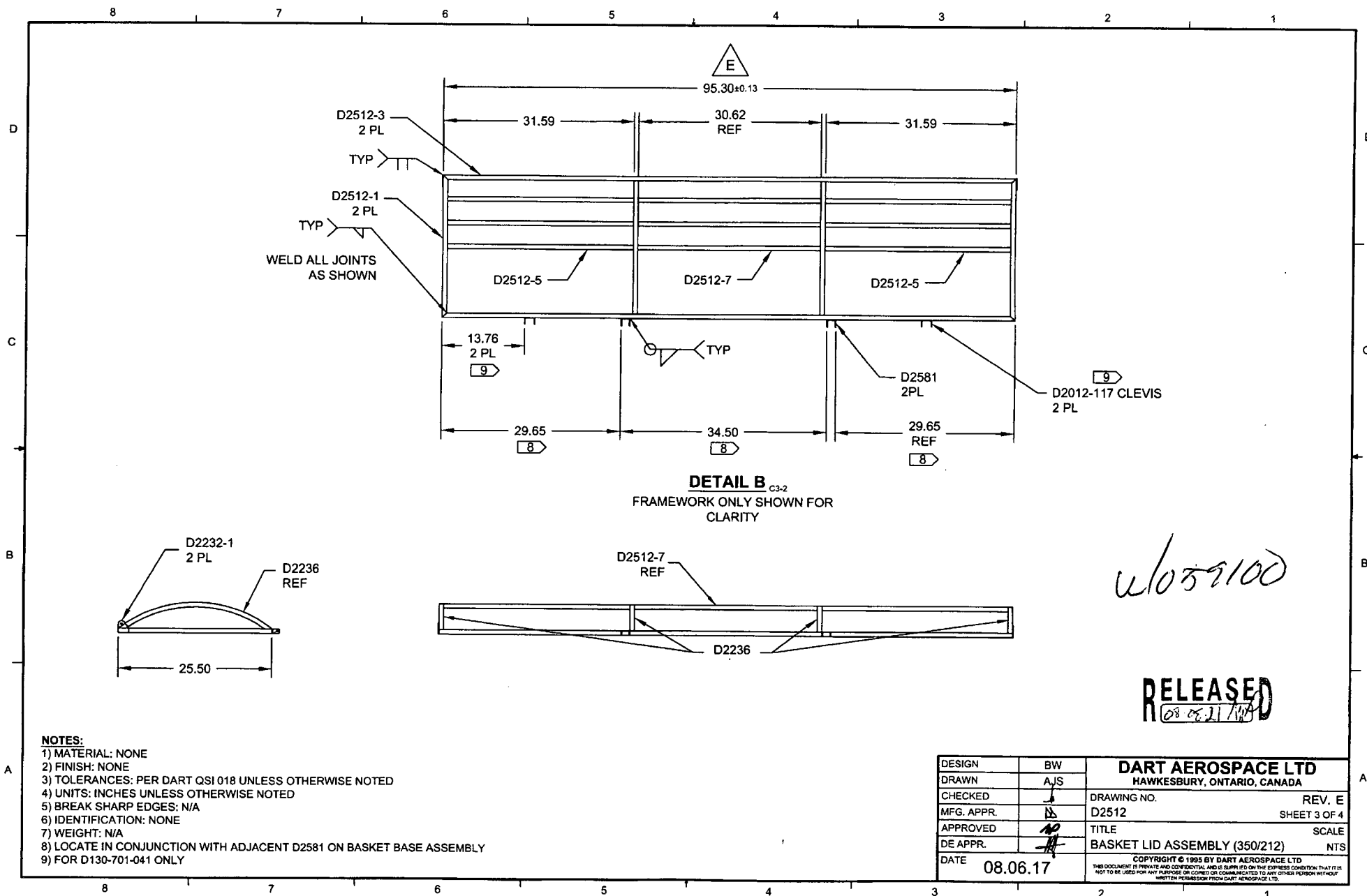
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**NOTE:** Date & initial all entries





DESIGN	BW	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	J	DRAWING NO.	REV. E
MFG. APPR.	S	D2512	SHEET 3 OF 4
APPROVED	10	TITLE	SCALE
DE APPR.	11	BASKET LID ASSEMBLY (350/212)	NTS
DATE	08.06.17	<small>COPYRIGHT © 1995 BY DART AEROSPACE LTD          THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS          NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT          WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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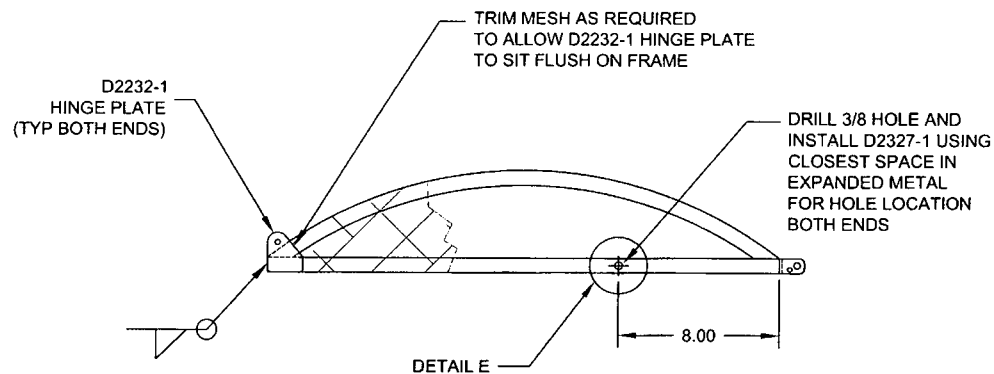
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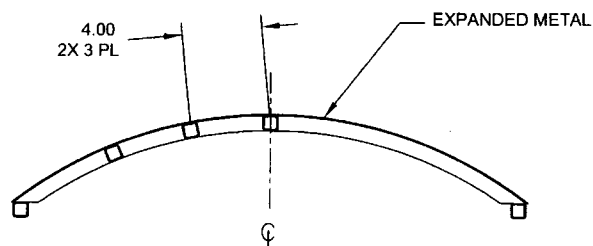
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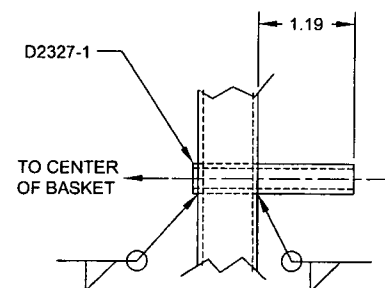
8 7 6 5 4 3 2 1



**VIEW C-C SIMILAR BOTH END RIBS** A5-2



**SECTION D-D SAME BOTH CENTER RIBS** A4-2



**DETAIL E** C6-4

w/o 59100

**RELEASED**  
08-06-21/17

DESIGN	BW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 4 OF 4
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8 7 6 5 4 3 2 1

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